# Work Order ID 70796

*Wednesday, June 15, 2011 10:57:03 AM*



**Item ID:** D2364 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Deck Plate, Fwd 350 Litt

**Start Date:** 6/15/2011 **Start Qty:** 8.00 **Cust Item ID:**

**Required Date:** 6/22/2011 **Req'd Qty:** 8.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** H **Date:** 11-06-15 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| D2364 | Rev F | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | B11-6-22 | | | |
| Waterjet | **Memo** | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D2364 ☐Dwg Rev: F ☐Prog Rev: F ☐2-Deburr if necessary | | | | | (12) | | | |
| 2624.063 | | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | B11-6-22 | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 8 11/06/12 | | | | (12) | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Work Order ID 70796

*Wednesday, June 15, 2011 10:57:03 AM*



**Item ID:** D2364
**Revision ID:**
**Item Name:** Deck Plate, Fwd 350 Litt
**Start Date:** 6/15/2011 **Start Qty:** 8.00
**Required Date:** 6/22/2011 **Req'd Qty:** 8.00
**Reference:**

**Accept** **Setup Start** **Stop**

**Cust Item ID:**
**Customer:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130<br>Small Fab<br>Small Fab | Small Fab | 0.00 | | | | | | | |
| | **Memo** 1- counter sink holes as per dwg D2364□2- deburr if necessary | 0.00 | | | | | | | |
| 140<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | **Memo** | 0.00 | | | | | | | |
| 150<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| | **Memo** | 0.00 | | | | | | | |

11/06/23 (62)

δ 11/06/23 (62)

12X Ø M-L 11/06/23

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Work Order ID 70796

*Wednesday, June 15, 2011 10:57:03 AM*



**Item ID:** D2364
**Revision ID:**
**Item Name:** Deck Plate, Fwd 350 Litt
**Start Date:** 6/15/2011
**Required Date:** 6/22/2011
**Reference:**

**Start Qty:** 8.00
**Req'd Qty:** 8.00

**Cust Item ID:**
**Customer:**

**Accept** **Setup Start** **Stop** **Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160<br>Powdercoat<br>Powder Coating<br>M115128 | Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 | 0.00 | | | | | | | |
| | **Memo** 1:30 START TIME: ☐OVEN TEMPERATURE: 320°F ☐FINISH TIME: 2:00 | 0.00 | | | | | | | |
| | | | | | | 12 | Ø | M | 11/06/27 |
| 170<br>QC<br>Quality Control | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | **Memo** | 0.00 | | | | | | | |
| | | | | | | 12 | Ø | M | 11/06/22 |
| 180<br>Packaging<br>Packaging | Identify as per dwg & Stock Location: ST225 | 0.00 | | | | | | | |
| | **Memo** | 0.00 | | | | | | | |
| | | | | | | CL | 11/06/28 | | X12 |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Work Order ID 70796

*Wednesday, June 15, 2011 10:57:04 AM*



**Item ID:** D2364
**Revision ID:**
**Item Name:** Deck Plate, Fwd 350 Litt
**Start Date:** 6/15/2011 **Start Qty:** 8.00
**Required Date:** 6/22/2011 **Req'd Qty:** 8.00
**Reference:**

**Accept**

**Setup Start**
**Stop**

**Cust Item ID:**
**Customer:**

**Run Start**
**Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 190 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

11/6/28

11-06-28
(12)

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Picklist Print



*Wednesday, June 15, 2011 10:57:10 AM*

**Work Order ID:** 70796

**Parent Item:** D2364

**Parent Item Name:** Deck Plate, Fwd 350 Litt

**Start Date:** 6/15/2011 **Required Date:** 6/22/2011

**Start Qty:** 8.00 **Required Qty:** 8.00

**Comments:** IPP REV. E□00.06.26□Removed P/O for powder coat□EC□
IPP Rev:F Now On Waterjet 06-07-03 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M2024T3S.063 | | Purchased | No | | | 100 | sf | 269.5700 | 0.6469 | 5.447579 | 8. | | |
| 2024-T3 .063 sheet | | | | | | | | | | | BIL. 6-22 | | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| MAT022 | 269.57 | |
| 113867 | 0.19 | |
| 117018 | 26.88 | |
| 117392 | 242.5 | |

(12)

117392

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 70796 |
|---|---|---|
| | | |
| **Description:** Litter Deck Plate Kit (350) | Part Number: | D2364 |
| | | |
| **Inspection Dwg:** D2364 **Rev:** F | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 6.624 | +/-0.010 | 6.628 | ✓ | | V PBO2 | |
| Ø0.171 | +0.005/-0.000 | .171 | ✓ | | V | |
| 0.354 | +/-0.010 | .354 | ✓ | | V | |
| 11.242 | +/-0.010 | 11.245 | ✓ | | PROWS02 | |
| 3.031 | +/-0.010 | 3.036 | ✓ | | V | |
| 1.903 | +/-0.010 | 1.903 | ✓ | | V | |
| 1.128 | +/-0.010 | 1.128 | ✓ | | V | |
| 0.354 | +/-0.010 | .352 | ✓ | | V | |
| 1.340 | +/-0.005 | 1.337 | ✓ | | V | |
| 2.326 | +/-0.010 | 2.346 | ✓ | | V | |
| 3.312 | +/-0.010 | 3.310 | ✓ | | V | |
| 4.298 | +/-0.010 | 4.297 | ✓ | | V | |
| 5.284 | +/-0.010 | 5.282 | ✓ | | V | |
| 6.151 | +/-0.010 | 6.151 | ✓ | | V | |
| 6.270 | +/-0.010 | 6.271 | ✓ | | V | |
| 0.354 | +/-0.010 | .354 | ✓ | | V | |
| 3.031 | +/-0.010 | 3.036 | ✓ | | V | |
| Ø0.656 | +0.005/-0.000 | .656 | ✓ | | V | |
| 5.003 | +/-0.010 | 5.005 | ✓ | | V | |
| 4.605 | +/-0.010 | 4.603 | ✓ | | V | |
| 1.776 | +/-0.010 | 1.777 | ✓ | | V | |
| 0.980 | +/-0.010 | .978 | ✓ | | V | |
| 4.487 | +/-0.010 | 4.490 | ✓ | | V | |
| 7.192 | +/-0.010 | 7.195 | ✓ | | V | |
| 7.567 | +/-0.010 | 7.566 | ✓ | | V | |
| 7.942 | +/-0.010 | 7.945 | ✓ | | V | |
| Ø0.191 | +0.005/-0.000 | .191 | ✓ | | V | |
| Ø0.197 | +0.005/-0.000 | .198 | ✓ | | V | |
| 11.145 | +/-0.010 | 11.142 | ✓ | | P | |
| 12.181 | +/-0.010 | 12.181 | ✓ | | T PBO1 | |
| 11.378 | +/-0.010 | 11.378 | ✓ | | P | |
| 11.776 | +/-0.010 | 11.776 | ✓ | | P | |
| 12.173 | +/-0.010 | 12.173 | ✓ | | T | |
| 4.690 | +/-0.010 | 4.692 | ✓ | | V | |
| 0.250 | +0.005/-0.000 | .252 | ✓ | | V | |
| 3.144 | +/-0.010 | 3.148 | ✓ | | V | |
| 0.171 | +0.005/-0.000 | .172 | ✓ | | V | |

| Measured by: | KB | Audited by: | | Prototype Approval: | N/A |
|---|---|---|---|---|---|
| Date: | 11-6-24 | Date: | 11/06/24 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 04.06.25 | New Issue P/O D350-616-015 | KJ/JLM | |
| B | 08.05.28 | 7.567 dimension revised | KJ/DD | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

DART

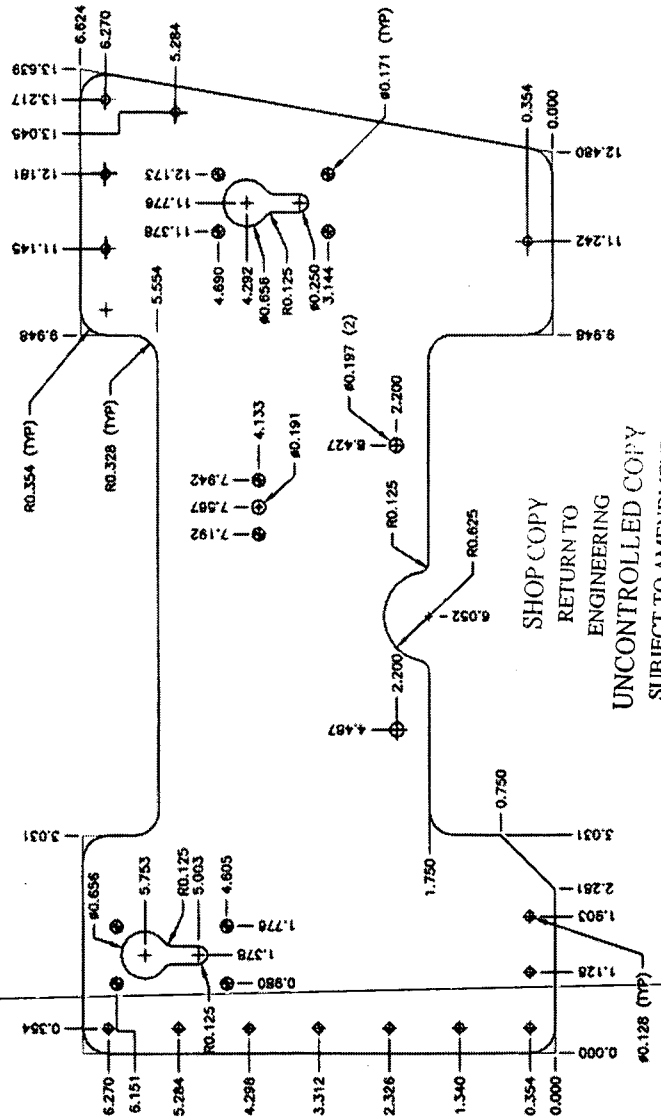
DA COPY ISSUED

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| KE | KE | | |
| CHECKED | APPROVED | DRAWING NO. | REV. F |
| DMM | CA | D2364 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 98.06.19 | | LITTER DECK PLATE, 350 | 2:5 |

| | | |
|---|---|---|
| A | 95.01.14 | NEW ISSUE |
| B | 95.02.09 | MOVED KEYWAY |
| D | 95.03.06 | 0.191 WAS 0.197 |
| E | 95.10.06 | GEOMETRY CHANGES |
| F | 98.06.19 | 0.063–0.071 THICK WAS 0.071 (TSR A371) |

RELEASED
99/06/22 KG

(UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)




COUNTER SINK HOLES:
◆ C'SINK Ø0.225 x 100°
⊕ C'SINK Ø0.308 x 100°

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70796

11 Oct-15

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063–0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1995 by DART AEROSPACE LTD

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries